

*Kustff*

Date: Tuesday, 04/07/2006 8:34:23 AM  
User: Linda Lacelle



**Process Sheet**

*Need by July 14th!*

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEBBING TIDY
Job Number :	27757		
Estimate Number :	11381		
P.O. Number :	N/A	Part Number :	D32153
This Issue :	04/07/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3215 REV C
First Issue :	28/06/2006	Project Number :	N/A
Previous Run :	25880	Drawing Revision :	C
		Material :	N/A
Written By :	<i>SEE COMMENT BELOW</i>	Due Date :	20/07/2006
Checked & Approved By :	<i>[Signature]</i>	Qty:	50 Um: Each
Comment :	Est. A 04.01.06 New issue KJ/RF		

**Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
		
	Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.3545 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify for D3215-3A Batch: <i>M15982</i>	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
		
	Comment: NC BRAKE Form D3215-3A as per Dwg D3215	

Date: Tuesday, 04/07/2006 8:34:23 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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06-07-10

Comment: INSPECT WORK TO CURRENT STEP

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

CPL 06-07-12

8.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

PD 06-07-12

(48)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-07-13

(48)

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-07-14

(48)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206/07/14

(48)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ID+stack

C206/07/14

(48)

13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-17

Job Completion



06-07-15

Date: Wednesday, 6/28/2006 4:18:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEBBING TIDY		
Job Number	: 27757				
Estimate Number	: 11381				
P.O. Number	:	Part Number	: D32153		See replacement w/o. attached.
This Issue	: 6/28/2006 S.O. No. :	Drawing Number	: D3215 REV C		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: C		
Previous Run	: 25880	Material	:		
Written By	:	Due Date	: 7/20/2006	Qty:	50 Um: Each
Checked & Approved By	:				
Comment	: Est. A04.01.06 New issue KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.3545 sf(s)  
 5052-H32 .040 Sheet  
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
 (M5052H32S.040)  
 Identify for D3215-3A  
 Batch: M15982

2.0	SHEAR	SHEAR
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N/A



Comment: SHEAR  
 Cut blank: 2.562" x 0.880", grain along 2.562"

3.0	HAAS1 WATER POT	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine D3215-3A as per Folio FA376 and dimensions  
 Use Stack of 10  
 Identify as D3215-3A

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

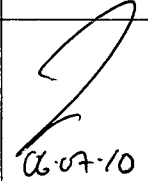
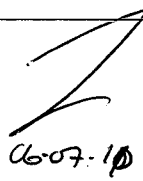
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/10	9	2 piece were out of tolerance to wide.		Scrap destroy	SB 06/07/10	 06-07-10		 06-07-10

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:18:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06-07-07 (50)

7.0

M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total: 1.3645 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
(M5052H32S.040)

Identify as D3215-3B

Batch:

M15982

FF 06-07-07

50

8.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.130" x 0.530"

Deburr D3215-3A/-3B

FF 06-07-07

50

9.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/07/00

48

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-10

48

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

CPL 06-07-12

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:18:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4:3

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

PACKAGING 1

PACKAGING RESOURCE #1.



Comment: PACKAGING RESOURCE #1

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

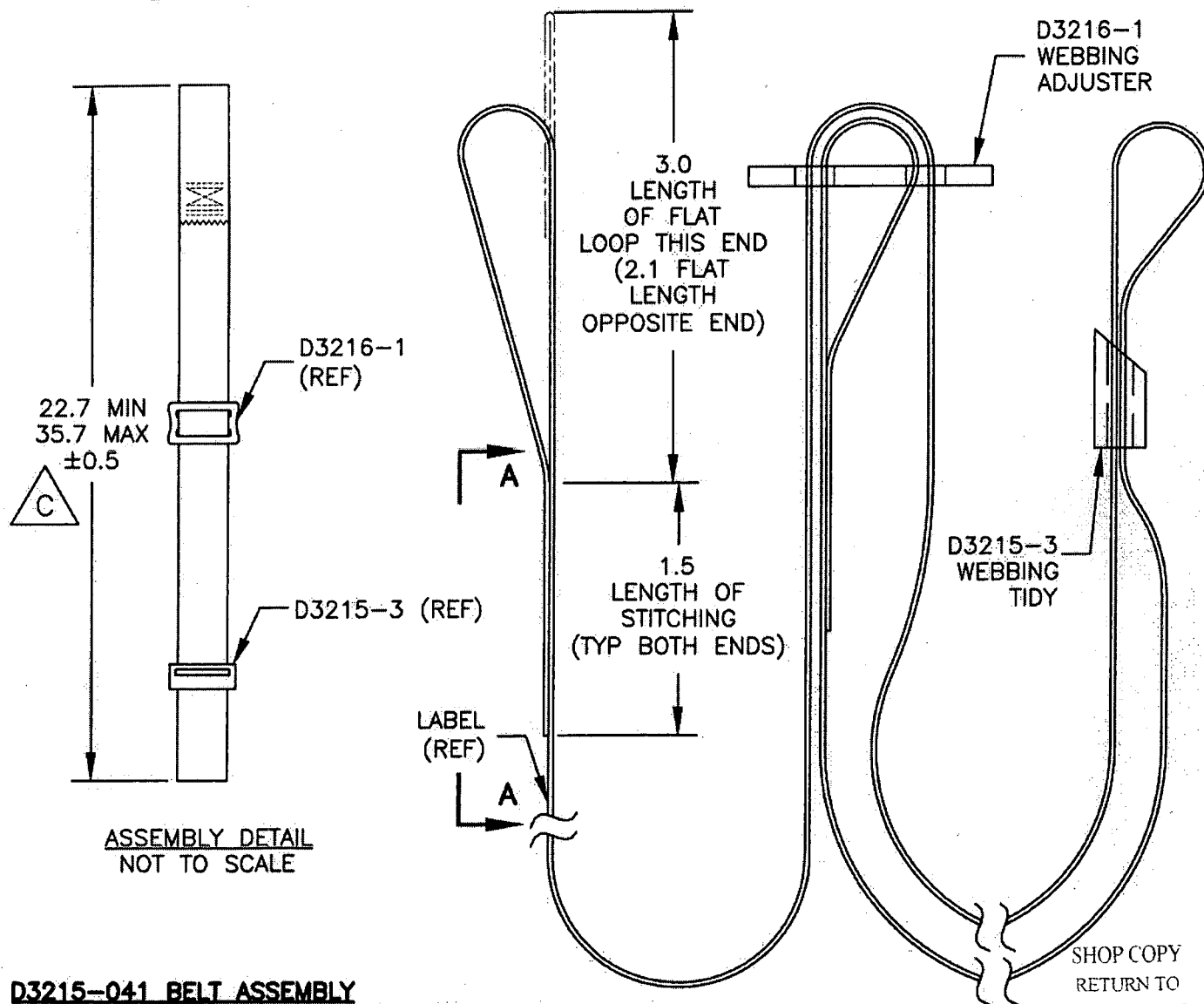






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CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3215 REV. C SHEET 1 OF 3
DATE	04.03.05	TITLE	BELT ASSEMBLY	SCALE NTS
A	03.09.19	NEW ISSUE		
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE		
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING		

RELEASED  
04.03.08



ASSEMBLY DETAIL  
NOT TO SCALE

#### D3215-041 BELT ASSEMBLY

- MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, TENSILE STRENGTH 5700 lb MIN)  
TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN  
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD  
LABEL = TYVEK
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER  
NO 27757

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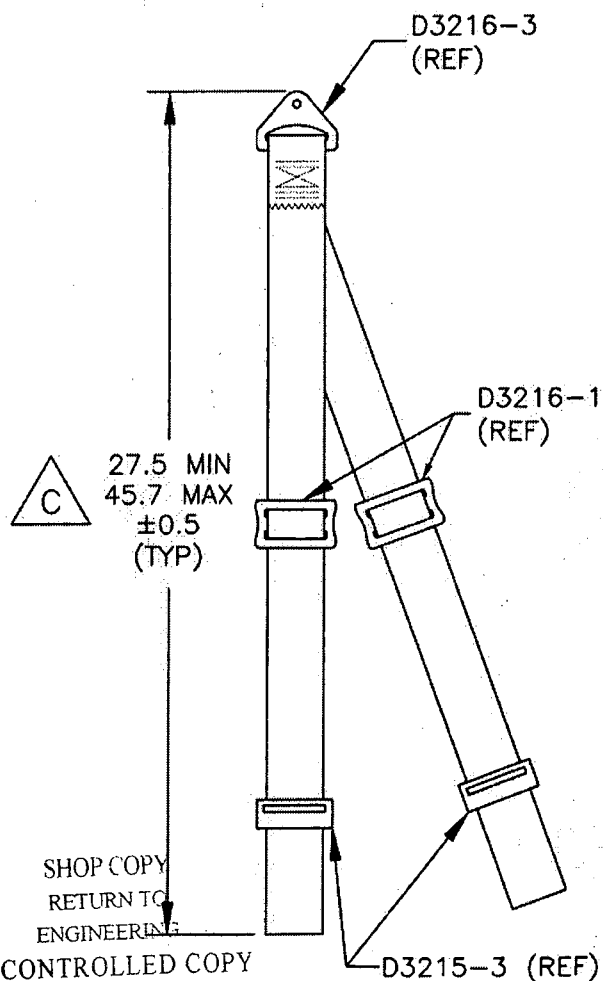
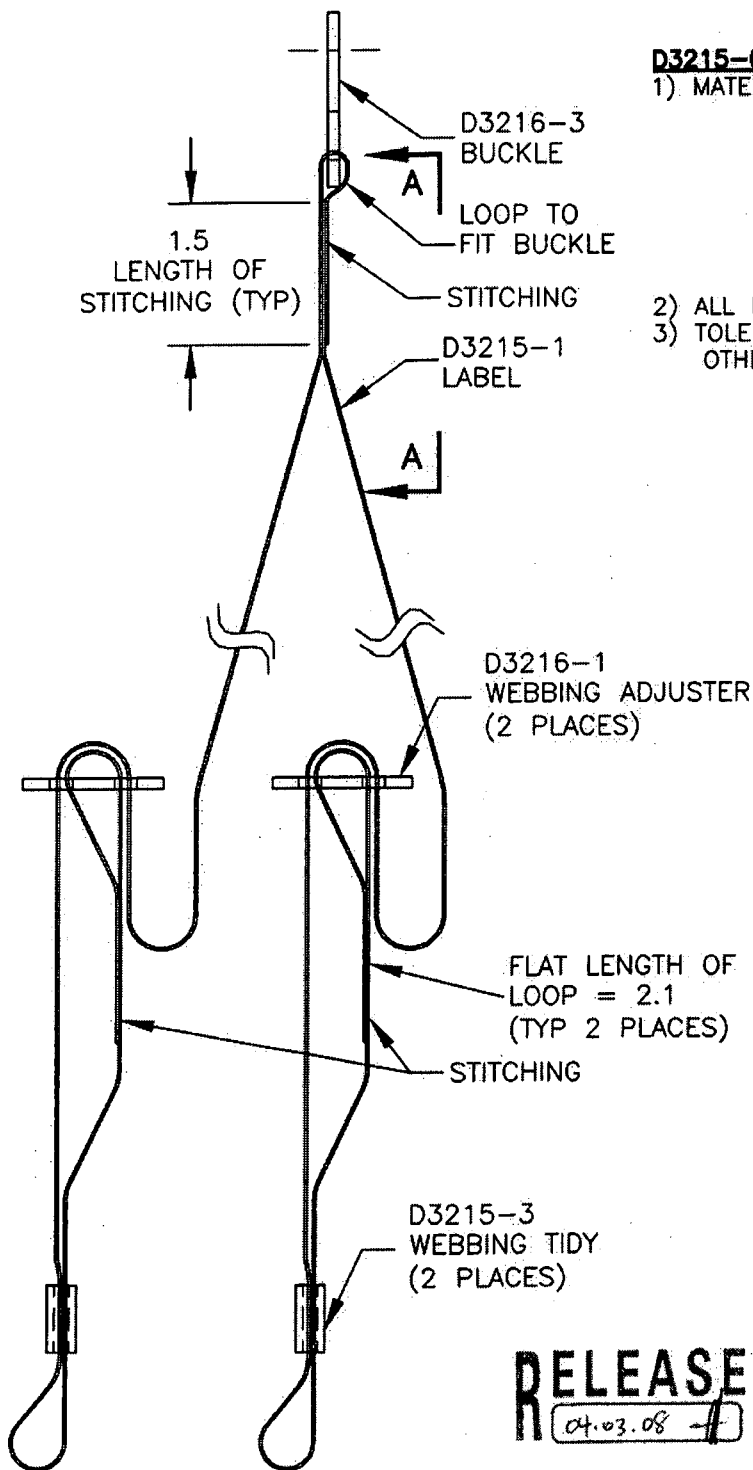
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CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 2 OF 3
DATE 04.03.05		TITLE BELT ASSEMBLY	SCALE NTS

### D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472  
(2" WIDE x 0.060" THICK  
BLACK POLYESTER WEBBING,  
CERTIFIED TO FAR 29.853A3,  
TENSILE STRENGTH 5700 lb MIN)  
THREAD = VT 295 TYPE II CLASS A SIZE 3,  
BLACK NYLON THREAD  
LABEL = TYEK
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED.



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04.03.08

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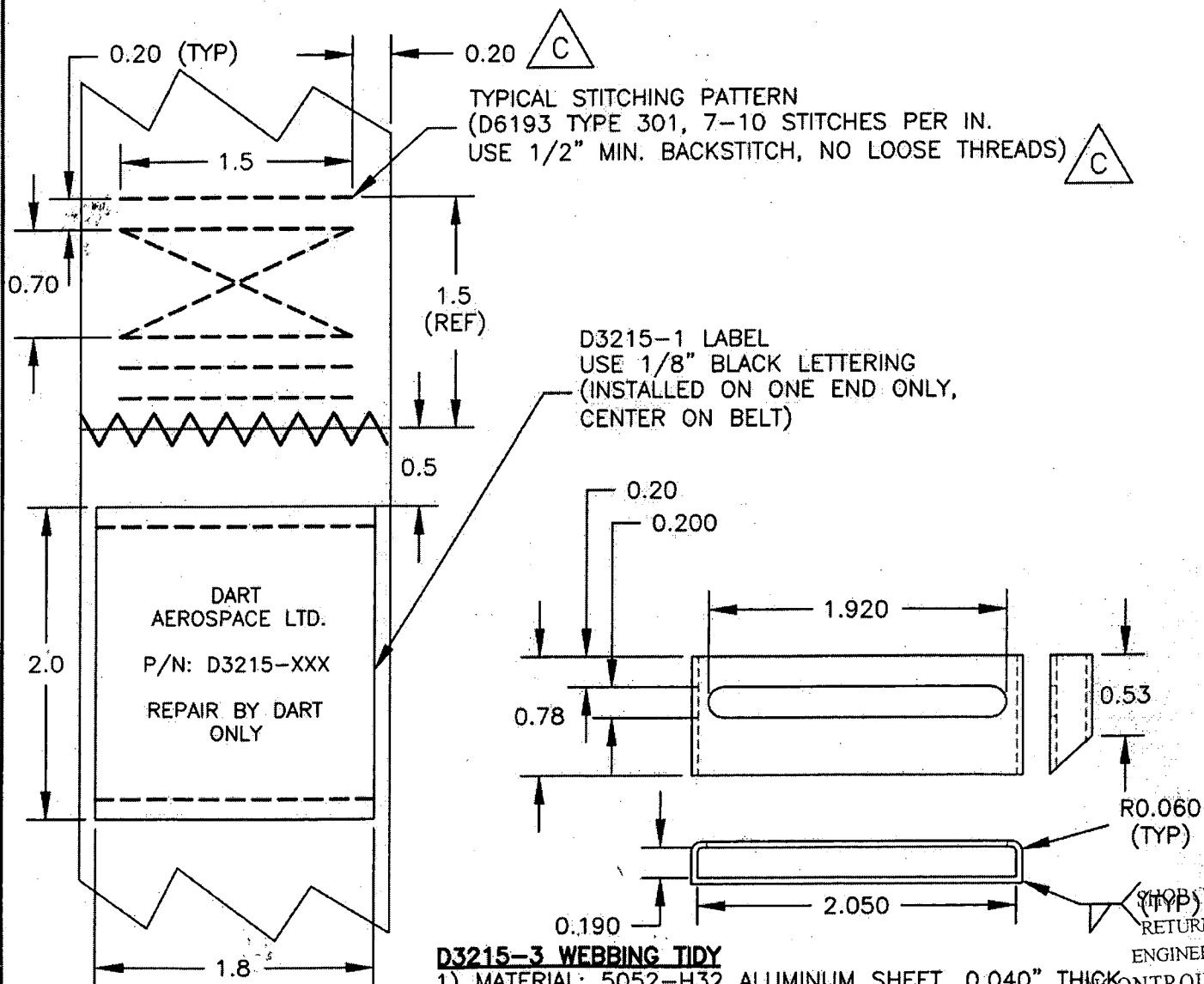
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05		TITLE HARNESS ASSEMBLY	SCALE 1:1

### VIEW A-A

XXX = 041 FOR D3215-041  
XXX = 043 FOR D3215-043



RELEASED  
04.03.08

#### D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK  
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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